

Date: Monday, 02/06/2008 8:11:12 AM
User: Jegg-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER AFT SADDLE
Job Number : 39621 -2	
Estimate Number : 11082	
P.O. Number :	Part Number : D5957
This Issue : 02/06/2008 S.O. No. :	Drawing Number : D5957 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 39606	Material :
Written By :	Due Date : 09/06/2008
Checked & Approved By :	Qty: 7 Um: 8 Each
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: 34875

DIP 08/06/03

S.F 08/06/02

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

DIP 08/06/03

S.F 08/06/02

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

DIP 08/06/03

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

QC 08/06/05

S.F 08/06/02

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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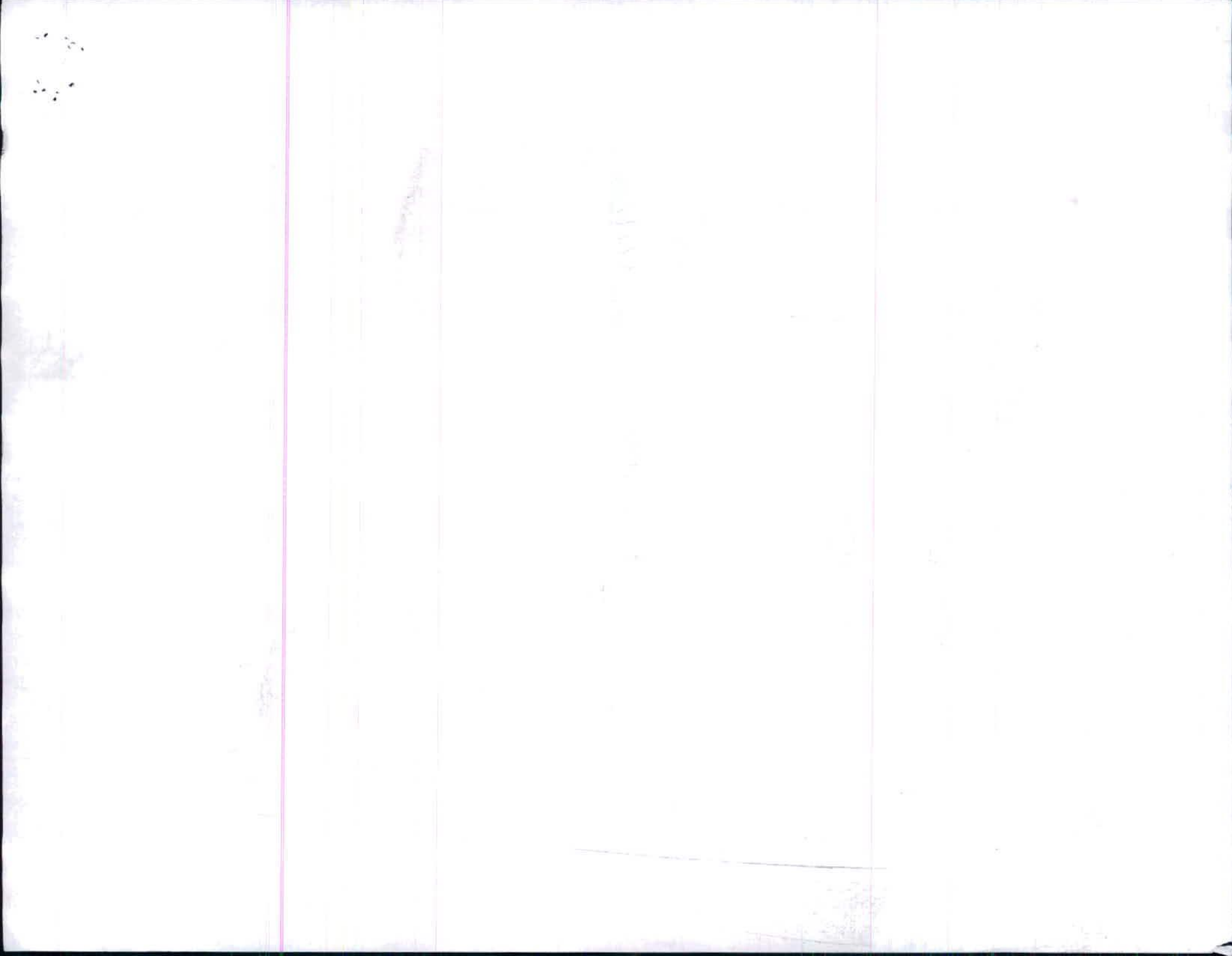


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

QC/BK 08-06-05

7



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39621

Part Number: D5957

Job Number: 

Seq. #: Machine Or Operation: Description :

6.0 POWDER COATING POWDER COATING



M107925



7A

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320 °C
9:30

M-1 08/06/09

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/09 7

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 421

AS 08/06/09

7

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10 7

Job Completion

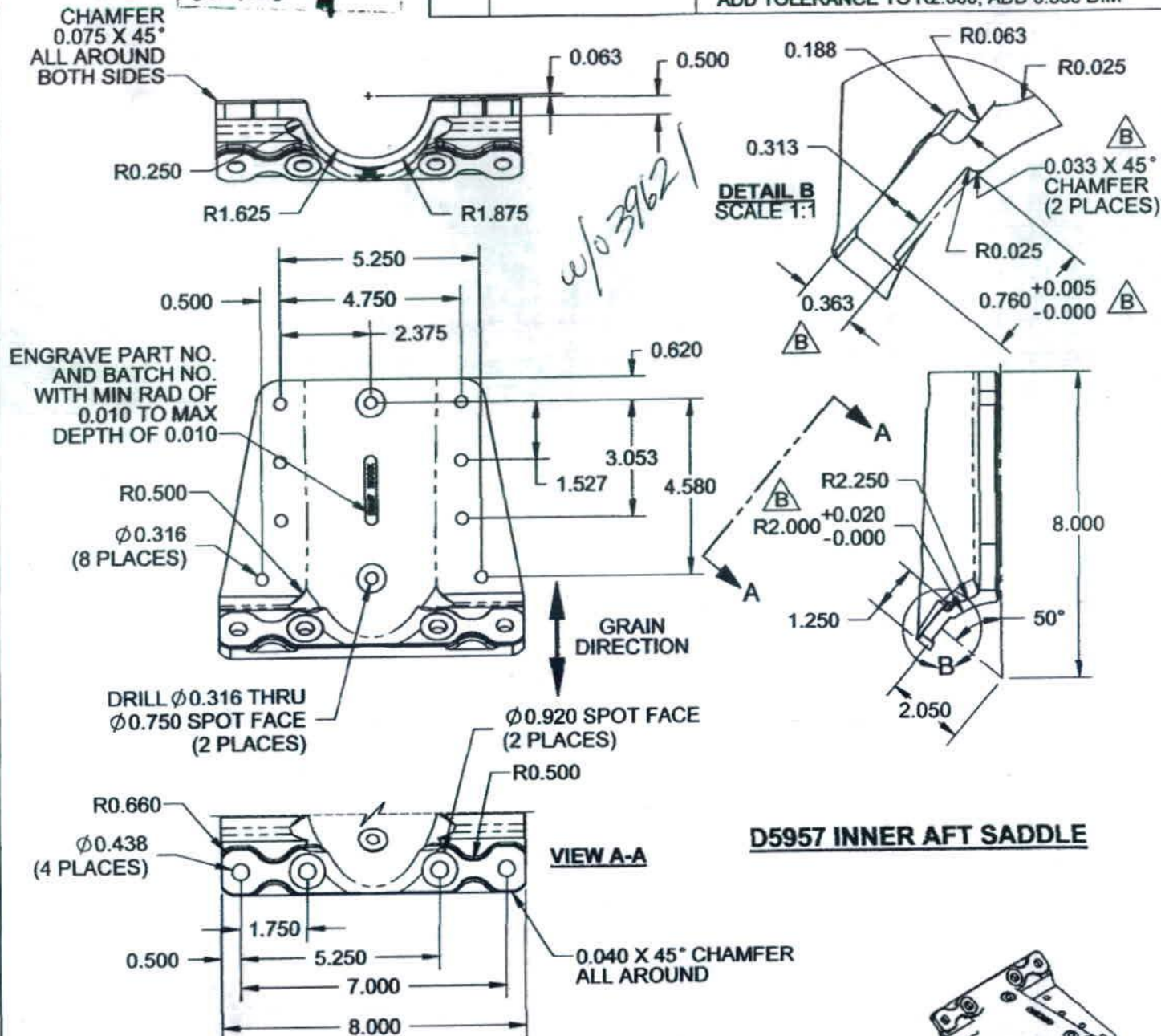


c 208/06/09



DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

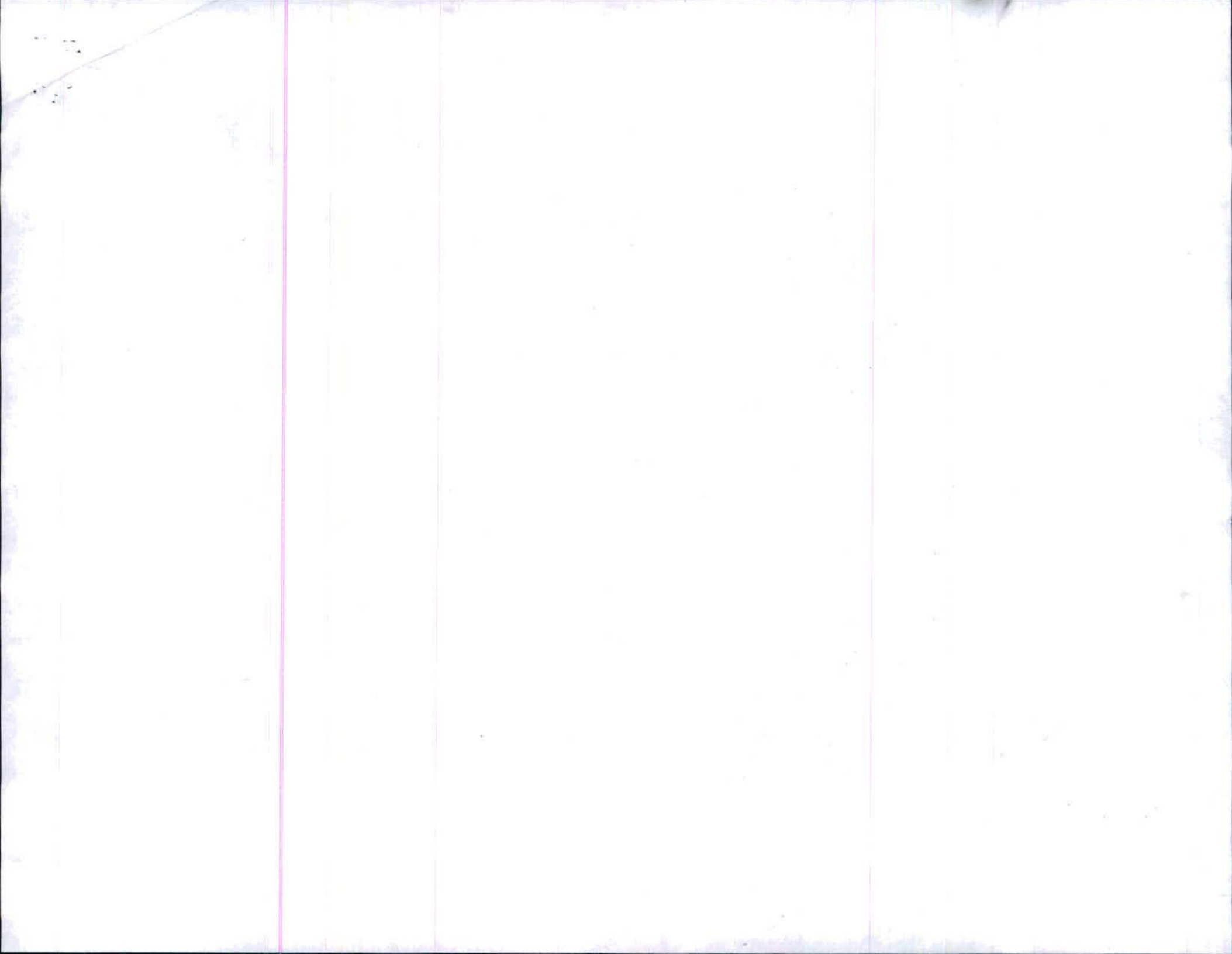
**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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DART AEROSPACE LTD		Work Order: 39621
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	X	1X	2X	3X		
A	0.438	0.443		.442		0.442	0.442		
B	1.745	1.755		1.748		1.7485	1.749		
C	5.245	5.255		5.248		5.250	5.250		
D	6.995	7.005		6.998		6.997	6.998		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.320	0.322		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.052	3.052	3.050	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	0.318		
L	0.495	0.505		.500	0.500	0.500	0.500		
M	0.490	0.510		.503	.503	.503	0.503		
N	1.865	1.885		1.878	1.885	1.885	1.885		
O	7.990	8.010		8.001		8.000	8.000		
P	2.240	2.260		2.250		2.250	2.250		
Q	0.307	0.312		.310		0.310	0.312		
R	0.760	0.765		.761		0.760	0.760		
S	0.490	0.510		.499		0.505	0.508		
T	1.625	1.645		1.634	1.6335	1.633	1.633		
U	2.000	2.020		2.007		2.006	2.006		
V	0.023	0.043		.033		0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject				Reject					

Measured by: ST
Date: 05/06/02 / 08/06/03

Audited by: [Signature]
Date: 01.06.02 / 29.08/06/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 3962/
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	4	5	6	7	By	Date
A	0.438	0.443		0.442	0.442	0.442	0.442		
B	1.745	1.755		1.748	1.749	1.750	1.750		
C	5.245	5.255		5.249	5.250	5.249	5.250		
D	6.995	7.005		7.001	7.001	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.7485		
G	0.315	0.322		0.322	0.322	0.322	0.322		
H	1.522	1.532		1.527	1.527	1.527	1.525		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.502	0.503	0.501		
N	1.865	1.885		1.885	1.880	1.880	1.8785		
O	7.990	8.010		7.999	7.999	7.999	7.999		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.493	0.493	0.495	0.495		
T	1.625	1.645		1.632	1.632	1.6335	1.6325		
U	2.000	2.020		2.003	2.003	2.004	2.004		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP
Date: 08/06/03

Audited by: RD
Date: 08/06/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

1
4
2
0
1

DART AEROSPACE LTD		Work Order: <u>39621</u>
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

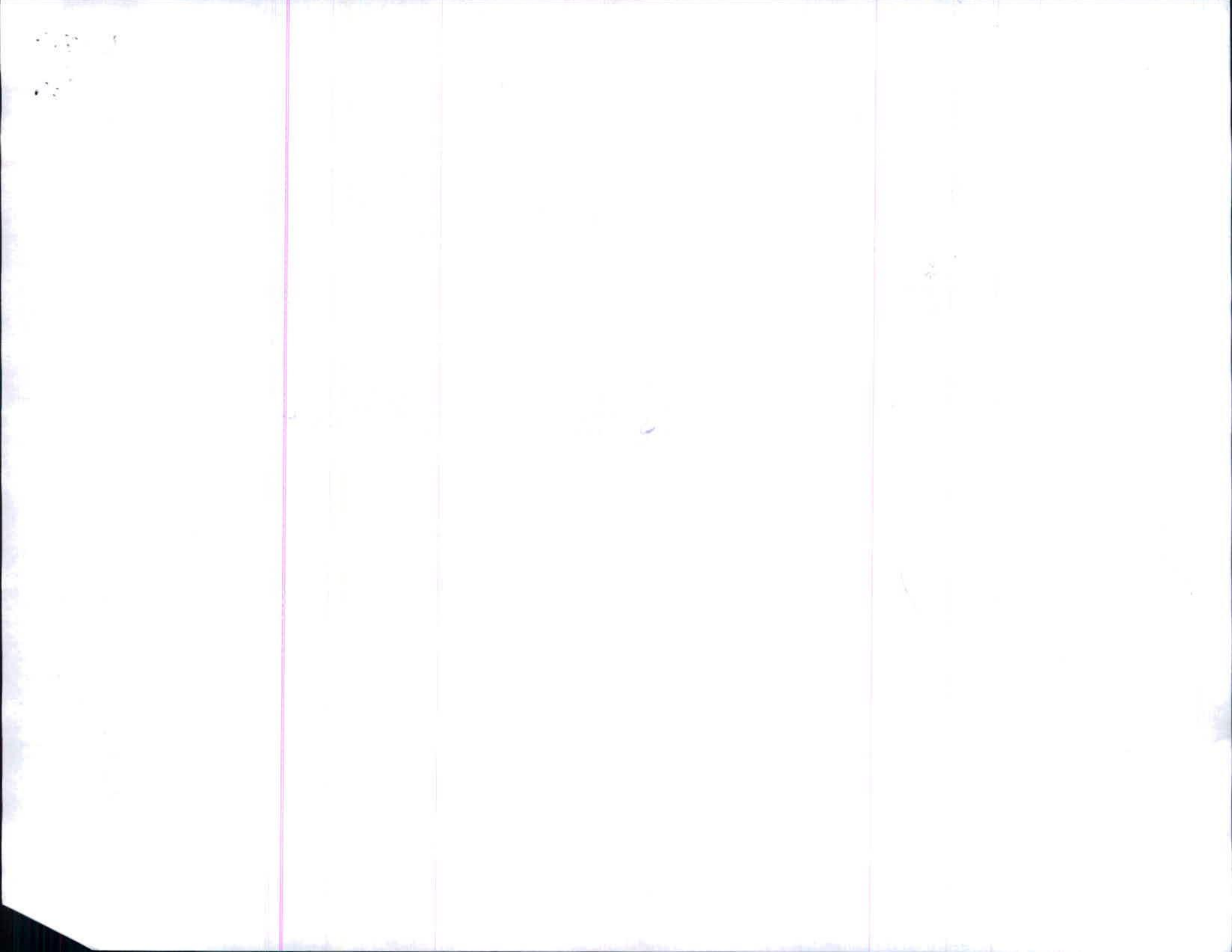
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	8	2	3	4		
A	0.438	0.443		0.442					
B	1.745	1.755		1.748					
C	5.245	5.255		5.250					
D	6.995	7.005		7.001					
E	5.240	5.260		5.250					
F	4.745	4.755		4.7485					
G	0.315	0.322		0.322					
H	1.522	1.532		1.526					
I	3.048	3.058		3.052					
J	4.575	4.585		4.580					
K	0.313	0.318		0.318					
L	0.495	0.505		0.500					
M	0.490	0.510		0.503					
N	1.865	1.885		1.880					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.307	0.312		0.3					
R	0.760	0.765		.310					
S	0.490	0.510		0.495					
T	1.625	1.645		1.6395					
U	2.000	2.020		2.005					
V	0.023	0.043		0.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DJP</u>
Date: <u>08/06/03</u>

Audited by: <u>RF</u>
Date: <u>08/06/03</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: N/A Fault Category: Prod / Machine Parts NCR: Yes No DQA: J Date: 08/06/12
 QA: N/C Closed: J Date: 08/06/13

NCR: <u>39621-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/03	2.0	instal the Saddle incorrectly on the 4axis.	<u>[Signature]</u>	- Add note to Polio to clarify hole location. See Attached Scrap: Replace Qty 1 Batch # <u>34875</u>	08/06/03 <u>DJP</u>	<u>[Signature]</u> 080610	<u>[Signature]</u> 080610	<u>[Signature]</u> 080610

NOTE: Date & initial all entries

D5957 HIHI SADDLE 4TH OP

PROG #4007

LOCATE WITH 2X 5/16" DOWELS
IN 3RD HOLE FROM FRONT OF SADDLE

FRONT SADDLE

CLAMPS X2

G110:
X=9.0
Y=0.0
Z=0.0 CENTER OF AXIS

